

Work Order ID 83881

April-26-12 1:50:23 PM

Ship May 2

83881

Page 1

Item ID: D3874-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Floor Protector

Start Date: 26/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/2012 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3874

Rev A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

4 BB 12/04/27

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240

Time IN: 4:45

Time OUT: 7:00

7 BB 12/04/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Item Name: Floor Protector

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Required Date: 01/05/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474
Dwg Rev: A
Folio Rev: A

4

12/04/27

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

4

12/04/27

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

x7

12/04/27

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

4

BB 12/04/30

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

4

BB 12/04/30

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Sorlesbi

(24)

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Required Date: 01/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

4x

SP
12-05-02

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/3

12-05-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

April-26-12 1:50:27 PM

Page 1

Work Order ID: 83881

83881

Parent Item: D3874-1

D3874-1

Parent Item Name: Floor Protector

Start Date: 26/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.118-90318-08 | | Purchased | No | | | 100 | sf | 1,383.746 | 4.38 | 17.52 | | | |

MI FXS 118-90318-08

Lexan Sheet

**

Location

therm

113127

Loc Qty

1383.746941

1383.74694

Loc Code

17.52 sf

DL
12/04/27

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NOTE: Date & initial all entries

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|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 83881 |
| Description: Floor Protector | | Part Number: | D3874-1 |
| Inspection Dwg: D3874 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than _____" | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | | | | |
| | | | | |
| | | | | |
| | | | | |

| | |
|------------------------|-----------------------|
| Measured by: <u>JB</u> | Date: <u>12/04/27</u> |
|------------------------|-----------------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.050 | Min | .054 | ✓ | | 1H-DI | |
| 0.065 | Min | .088 | ✓ | | | |
| 0.5 | Min | .558 | ✓ | | | |
| | | | | | | |
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|-------------------------|-----------------------|
| Measured by: <u>JB</u> | Date: <u>12/04/30</u> |
| Audited by: <u>DK</u> | Date: <u>12/04/30</u> |
| Prototype Approval: N/A | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-----------|
| A | 09.09.15 | New Issue | KJ | <u>JA</u> |

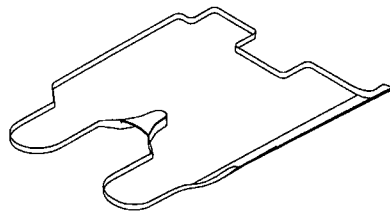
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

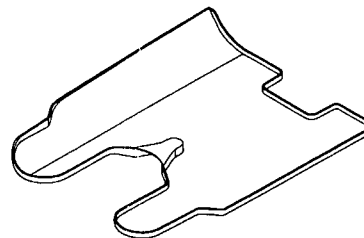
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NOTE: Date & initial all entries



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83881

RELEASED
29/09/05 MB

| | | | | | |
|---|----|---|--------------|----|----------|
| A | | NEW ISSUE | | PH | 09.01.29 |
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | PH | | | | |
| CHECKED | | DRAWING NO. | REV. A | | |
| MFG. APPR. | | D3874 | SHEET 1 OF 3 | | |
| APPROVED | | TITLE | SCALE | | |
| DE APPR. | | FLOOR PROTECTOR | NTS | | |
| DATE | | 09.01.29 | | | |
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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

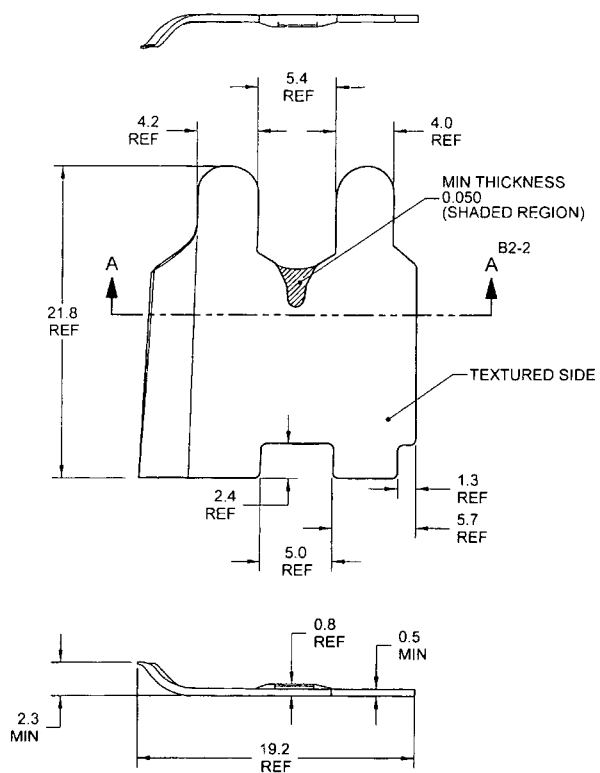
A

D

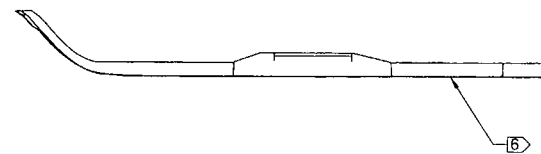
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B

A



D3874-1 FLOOR PROTECTOR

SECTION A-A
SCALE 2XRELEASED
09/25/2014

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

| | | | |
|------------|----------|--|--------------|
| DESIGN | PAH | DART AEROSPACE LTD | |
| DRAWN | PAH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PAH | DRAWING NO. | REV. A |
| MFG. APPR. | PAH | D3874 | SHEET 2 OF 3 |
| APPROVED | PAH | TITLE | SCALE |
| DE APPR. | PAH | FLOOR PROTECTOR | NTS |
| DATE | 09.01.29 | COPYRIGHT © 2009 BY DART AEROSPACE LTD | |
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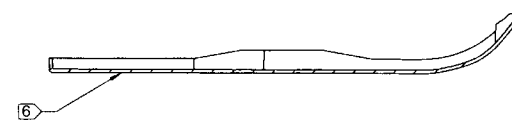
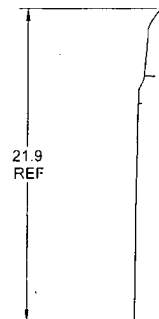
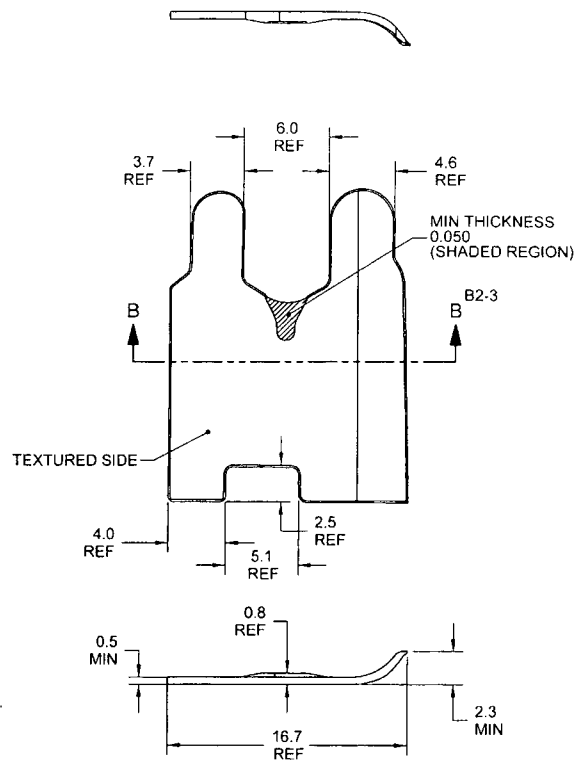
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NOTE: Date & initial all entries



SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

RELEASED
09/25/09

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

| | | | |
|------------|----------|---|--------------|
| DESIGN | PA | DART AEROSPACE LTD | |
| DRAWN | PA | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PA | DRAWING NO. | REV. A |
| MFG. APPR. | PA | D3874 | SHEET 3 OF 3 |
| APPROVED | PA | TITLE | SCALE |
| DE APPR. | PA | FLOOR PROTECTOR | NTS |
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